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APPLICANT : PILOT CORP:THE;

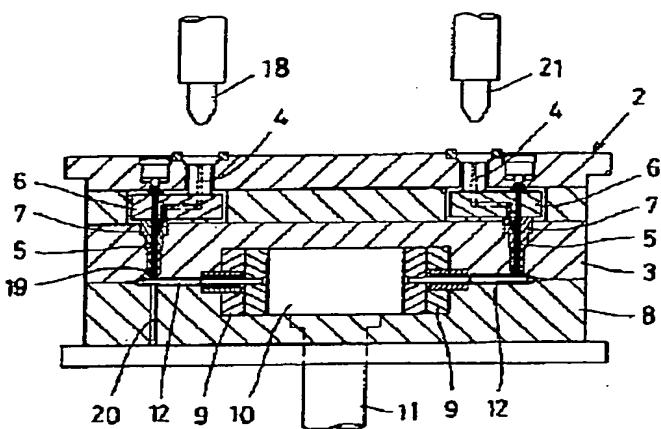
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TITLE : SHAFT TUBE OF WRITING UTENSIL

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ABSTRACT : PROBLEM TO BE SOLVED: To prevent the uneven wall thickness of a shaft tube from developing by a method wherein a molding is performed with a mold assembly having hot runners in the state that a valve pin is buried in a molding in a valve gate system.

SOLUTION: This shaft tube 1 is molded with a mold assembly 2 having hot runners. Under the condition that a fixed die 3 and a movable die 8 are closed together, a thermoplastic resin flows through a primary nozzle 18 to a primary spool 4 and a runner 5 so as to pass through a gate 19 having a bore of 1.2 mm toward a core pin 12 in order to fill within the mold 14 of a shaft tube main body, resulting in molding the shaft tube main body 13. In order to prevent the uneven wall thickness of the shaft tube main body due to the curving of the core pin caused by the abutting of a resin against the core pin 12 from developing, a back-up pin 20 is attached to the opposite side of a gate 19 to the runner under the condition being pinched with the core pin 12 between in the state that the tip of the back-up pin 20 is abutted against the core pin 12.

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